

Date: Monday, 22/09/2008 1:03:18 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FITTING		
Job Number	: 42170			Part Number	: D32991		
Estimate Number	: 10438			Drawing Number	: D3299 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 22/09/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 29/09/2008	Qty:	20
Previous Run	: 41828			Um:	: Each		
Written By	: <u>JLD 089-22</u>						
Checked & Approved By	: <u>JLD 089-22</u>						
Comment	: Est Rev:A 04.10.04 New issue KJ/JLM Est Rev:B 07-06-11 Removed Manual Machining & Hex Bar JLM						

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

Comment: Qty.: 0.2013 f(s)/Unit Total : 4.0257 f(s)
6061T6 BAR 1.250" X1.250"
Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8)

Batch: M109058
08/09/30

2.0 HARDINGE HARDINGE CNC LATHE SMALL

HARDINGE CNC LATHE SMALL
Cut blank: 2.200" long
Turn as per Folio FA451 and Dwg D3299

21 05/09/30

QC2		INSPECT
-----	---	---------

INSPECT PARTS AS THEY COME OFF MACHINE

COMMON INSPECTION TOOLS THEY COME OFF MACHINE

Comment: HAAS
Machine as per Folio FA451 and Dwg D3299
CHAMFER PART USING CHAMFER MACHINE AS PER DWG D3299
Deburr

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 1:03:18 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 42170

Part Number: D32991

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC8	SECOND CHECK
7.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
8.0	PACKAGING 1	PACKAGING RESOURCE #1
9.0	QC5	INSPECT WORK TO CURRENT STEP
10.0	PACKAGING 1	PACKAGING RESOURCE #1
11.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: SECOND CHECK *88/08/10/20*

Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: *7433*
Anodize as per Dwg D3299
Possible Supplier: TNM Paint
Material release note is required
C 208110123 (20)

Comment: PACKAGING RESOURCE #1
Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached
Rec 10/30 (20)

Comment: INSPECT WORK TO CURRENT STEP
88/08/10/30 + 20

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *ST 82* *88/08/10/31*

Comment: FINAL INSPECTION/W/O RELEASE *08/11/03/08*

Job Completion



U 08/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 52641 432
P 00835

5230

DART AEROSPACE LTD	Work Order:	<u>4/21/20</u>
Description: Fitting	Part Number:	D3299-1
Inspection Dwg: D3299 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>SD</u> / <u>JL</u>	Audited by: <u>LS</u>	Prototype Approval: N/A
Date: <u>08/13/18</u>	Date: <u>08/10/20</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	05.05.25	Ø0.302 was Ø0.312; 1.09 added	KJ/JLM	
C	08.07.23	Dwg Rev updated	KJ/DD	
D	08.09.04	Dimensions revised per Rev B	KJ/DD	 

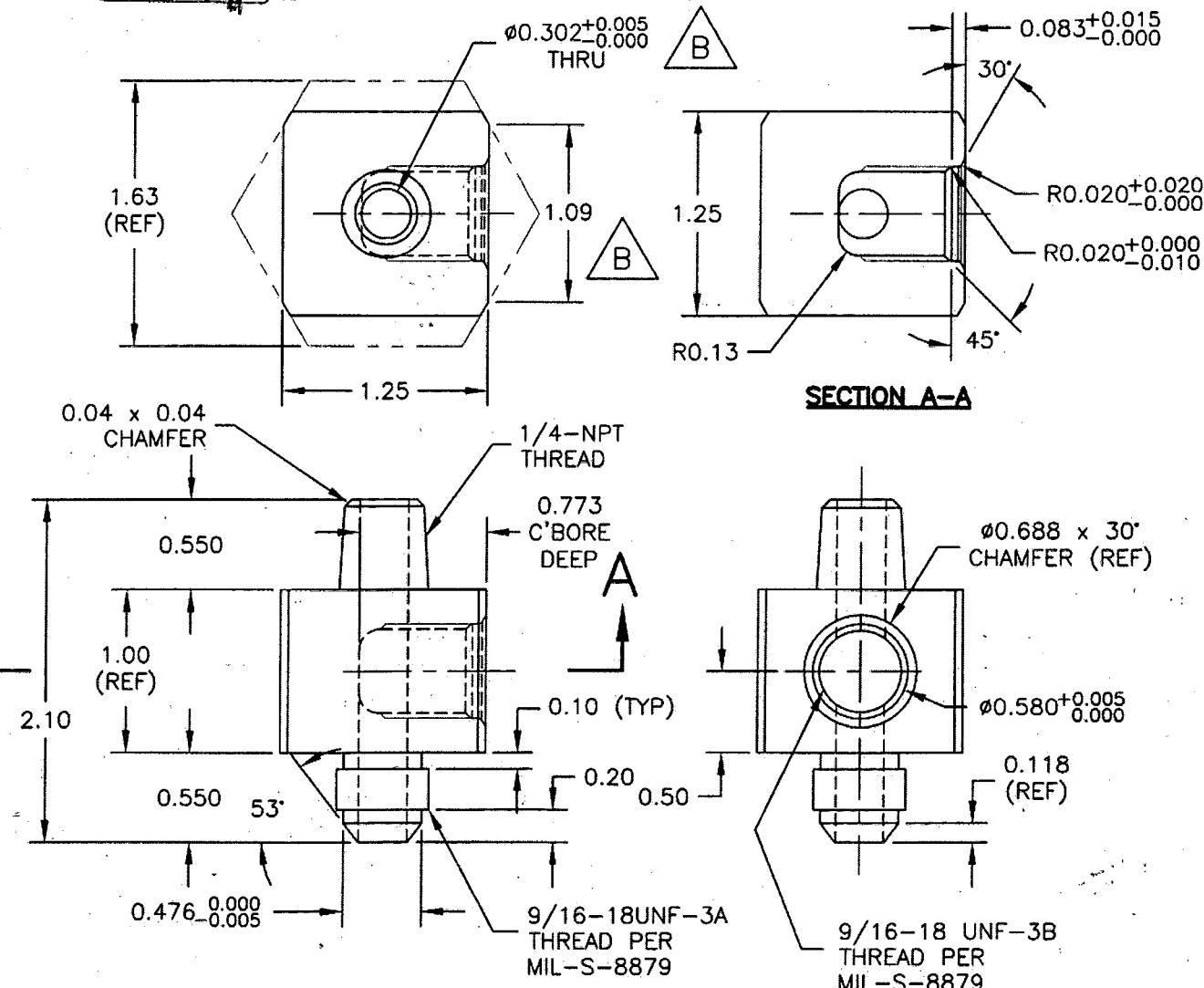
- 04289

3222



DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PF</i>	APPROVED <i>PF</i>	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; $\phi 0.302$ WAS $\phi 0.297$	

RELEASED
05.04.28 *PF*



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1-625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WITHOUT NOTICE

WORK ORDER

NO. 4210

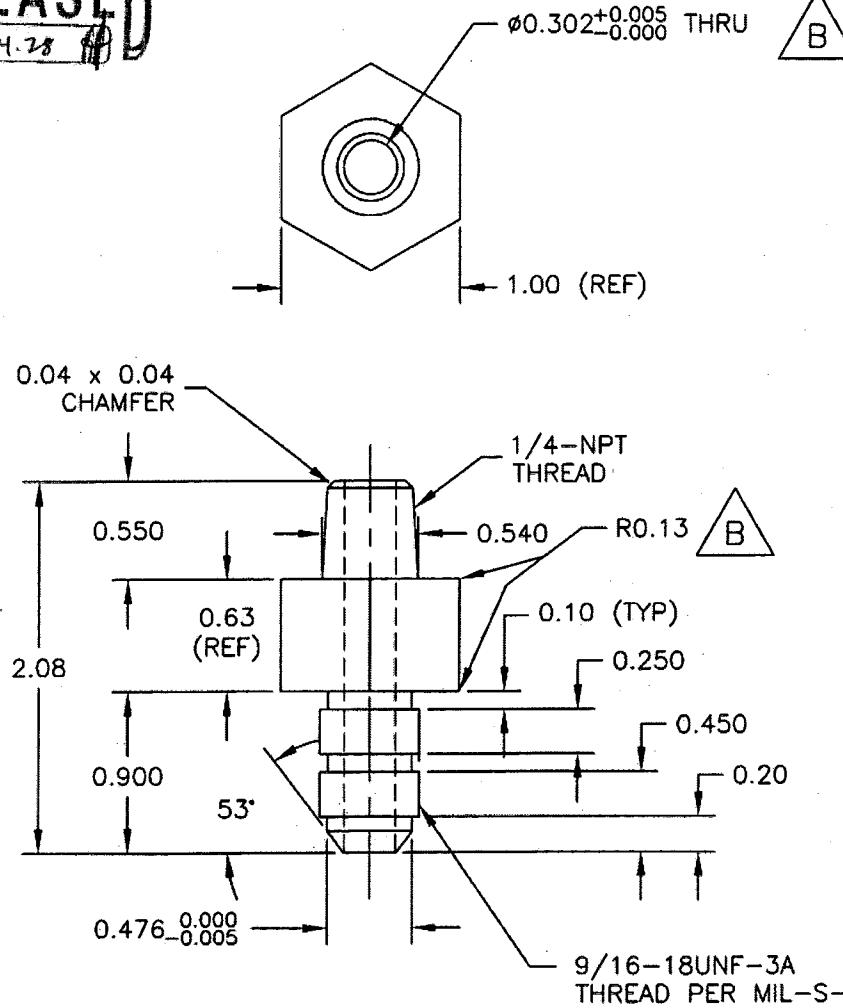
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3299
DATE 05.04.28		REV. B SHEET 2 OF 3 SCALE 1:1 TITLE FITTING

RELEASED
05.04.28



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIb
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
NO. 4210

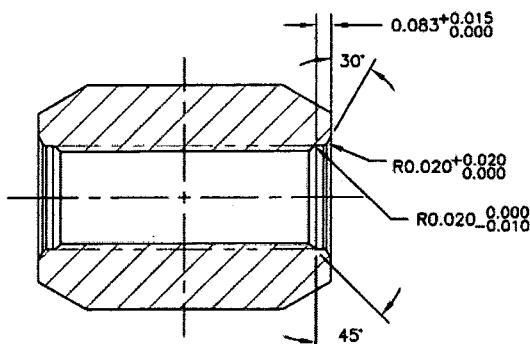
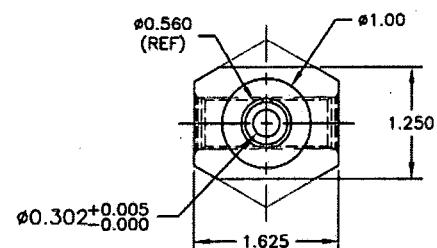
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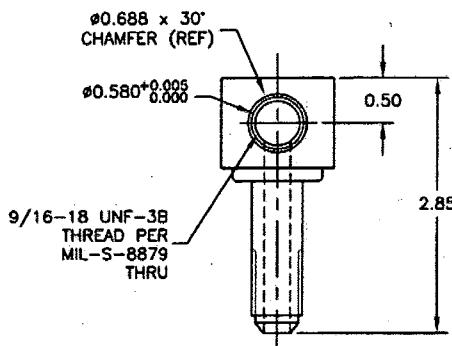
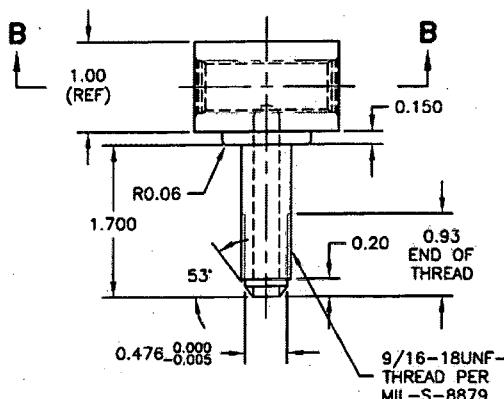


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CHECKED <i>TH</i>	APPROVED <i>TH</i>	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28	TITLE FITTING	SCALE 1:2	

RELEASED
05.04.28 *TH*



SECTION B-B
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER

NO. 00200

TNM**ANODISATION et PEINTURE TNM INC.****C. OF C**

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2
 Telephone: (514) 429-7777 Fax: (514) 429-5108
 Certifié ISO 9001-2000 certified
 approuvé NADCAP approved

69484

28-Oct-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
 1270 ABERDEEN STREET
 HAWKESBURY ONTARIO
 K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

NO. DE COMMANDE: 7433
PURCHASE ORDER/



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	20	20	D3299-1 B42170	BLUE. ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER
2	3	3	41232-200-002-001 B42265	BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager Q.D.Q.



TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

**FACTURE
INVOICE****69484 Rev.00**

28-Oct-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

**NO. DE COMMANDE: 7433
PURCHASE ORDER/****CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER	DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	20	20	D3299-1	B42170	\$0.00	\$0.00
2	3	3	41232-200-002-001	B42265	\$0.00	\$0.00
MINIMUM CHARGE						\$225.00
						SUB TOTAL: \$225.00
						TPS/GST: \$11.25
						TVQ/PST: \$0.00
						TOTAL AMOUNT DUE: \$236.25

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE**CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS**

En cas de perte ou de dommages dû à la valeur intrinséque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.